

Work Order ID 67131

Wednesday, March 09, 2011 9:51:14 AM

Page 1

Item ID: D135-751-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube Installation

Start Date: 3/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3507	Rev C
-------	-------

0.00

100



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

8 w/03/29

HJ for BG 11-3-28

B67131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

1 0 BEU/03/15

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/03/15

70

7

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

30 11/03/15

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0

3E 11/03/15

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo 1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F" 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 A/R 241 Sike Flex Batch: <u>116040</u> Exp Date: <u>11/09/30</u> start time: <u>4:00</u> end time: <u>4:30</u> 5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D. A/R AL ROD Batch: <u>mill 305</u> 6-Grind welds flush 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.	0.00							

11/03/15

BE 11/03/17

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



S ulos 1/7

(X)

1 Q BEN/03/17

S ulos 1/7

(X)

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Stop

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BR 11-3-18

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 115951
START TIME: 11:15
OVEN TEMPERATURE: 320°
FINISH TIME: 11:45

1 BR 11-3-18

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11-03-23

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo Install Wearplate & Ground Wire inserts as per Dwg D3507.	0.00							
250	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo Inspect Inserts	0.00							

1 0 M 11/03/28

N/A

CE 11.03.28

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	<p>1-Inspect for Foreign objects</p> <p>2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"</p> <p>A/R 241 Sika Flex Batch: <u>11116040</u></p> <p>Exp Date: <u>11/09</u></p> <p>3-Install Wearplates as per Dwg D3507,</p> <p>Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube</p> <p>Do not Install Scews where indicated on Dwg(Note #6)</p> <p>A/R 241 Sika Flex Batch: <u>11116040</u></p> <p>Exp Date: <u>11/09</u></p> <p>4-Install Plug assemblys with lubricate as per Dwg D3507.</p> <p>Batch: <u>11114189</u></p> <p>5- Wing Walk as per Dwg D3507 and QSI 005 4.4</p> <p>Batch: <u>11116040</u></p>								
270	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8/10/20

(70)

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Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/2011 SP

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulaster

10

300

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011

Location: 81

PPP Rev: B

11/3/2011 SP

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30
MF
11-03-29

Picklist Print

Wednesday, March 09, 2011 9:51:07 AM

Page 1

Work Order ID: 67131

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation



Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3507-1-BENT 		Manufactured	No			120	Each	2.0000	1	1			
Skidtube Assembly EC135													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				2					
				62291				1					
				62292				1					
D3504-1 		Manufactured	No			170	Each	18.0000	2	2			
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				18					
				53742				18					
D3504-3 		Manufactured	No			170	Each	30.0000	1	1			
Crossbolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				30					
				31232				10					
				53743				20					

BE 11/03/15
 67132-1

BE 11/03/16

2

BE 11/03/16

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-5 Manufactured No 170 Each 18.0000 2 2
Crossbolt Spacer

Location Loc Qty Loc Code

LG 18
36181 2
53744 16

D3505-1 Manufactured No 170 Each 0.0000 1 1

Web

D3506-1 Manufactured No 190 Each 70.0000 4 4

Doubler

Location Loc Qty Loc Code

ST063 70
51789 70

D3506-3 Manufactured No 190 Each 66.0000 2 2

Doubler

Location Loc Qty Loc Code

ST063 66
51790 66

MS20601-AD4W3 Purchased No 190 Each 3,523.000 12 12

Rivet

Location Loc Qty Loc Code

ST321 3523
114538 3523

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Picklist Print

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Work Order ID: 67131

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Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased

No

240

Each

1,538.000

38

38



Insert



HL 11/03/23

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1517

113238

17

115502

500

116800

1000

x38

ALS4-1032-225 Purchased

No

260

Each

3,809.000

1

1



Insert



HL 11/03/23

Location

Loc Qty

Loc Code

PK011

3809

110768

3809

x1

AN3C4A Purchased

No

260

Each

2,161.000

31

31



BOLT



HL 11/03/23

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

x31

W/O:		WORK ORDER CHANGES					
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Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

260

Each

1,008.000

2

2



Bolt



HL 11/03/23

Location

Loc Qty

Loc Code

ST350

1008

107862

68

108302

34

114330

11

115015

13

115371

4

115422

100

115835

178

116419

500

116549

100

x2

AN526C1032R10

Purchased

No

260

Each

390.0000

2

2



Screw



HL 11/03/23

Location

Loc Qty

Loc Code

ST327

100

114494

100

ST328

290

108062

126

110049

164

x2

AN960C10L

NAS1149C0332
R

Purchased

No

260

Each

61.0000

33

33



washer



HL 11/03/23

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

M116304 x33

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Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

35.0000

1

1



Cap, 105 Skidtube



11/03/23

Location

Loc Qty

Loc Code

FP4

35

52057

35

X1

D2965-3

Manufactured No

260

Each

7.0000

1

1



Cap



11/03/23

Location

Loc Qty

Loc Code

FP

7

50560

3

52282

4

X7

D3492-041

Manufactured No

260

Each

77.0000

4

4



Plug Assembly



11/03/23

Location

Loc Qty

Loc Code

FP013

77

59114

1

62210

3

63994

29

65068

44

X4

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Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

260

Each

125.0000

4

4



Plug Assembly



u/03/23

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

123

59117

1

59190

4

63996

2

65070

16

66150

20

66931

80

x4

D3492-047

Manufactured No

260

Each

37.0000

2

2



Plug Assembly



u/03/23

Location

Loc Qty

Loc Code

FP

37

28961

26

39722

11

x2

D3508-1

Manufactured No

260

Each

19.0000

1

1



Wearplate



u/03/23

Location

Loc Qty

Loc Code

FP

5

42973

1

51261

4

FP-16

14

61020

14

x1

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:51:10 AM

Page 7

Work Order ID: 67131

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3



Wearplate

Manufactured No

260

Each

8.0000

1

1



11/03/23

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

7

62882

1

65192

6

1

D3508-5



Wearplate

Manufactured No

260

Each

5.0000

1

1



11/03/23

Location

Loc Qty

Loc Code

FP

1

42251

1

FP21

4

51388

4

1

D3508-7



Wearplate

Manufactured No

260

Each

3.0000

1

1



11/03/23

Location

Loc Qty

Loc Code

FP

1

31198

1

FP21

2

60336

2

1367159

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:51:10 AM

Page 8

Work Order ID: 67131

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 3/9/2011



Required Date: 3/9/2011

Start Qty: 1.00



Required Qty: 1.00

D3558-1 Manufactured No 260 Each 16.0000 1 1

 Gasket  M 11/03/23



Location	Loc Qty	Loc Code
FP	16	
42533	1	
50925	15	

D3558-3 Manufactured No 260 Each 6.0000 1 1

 Gasket  M 11/03/23

Location	Loc Qty	Loc Code
FP	6	
42253	1	
55468	5	

D3558-5 Manufactured No 260 Each 6.0000 1 1

 Gasket  M 11/03/23

Location	Loc Qty	Loc Code
FP	6	
43244	1	
50926	5	

D3558-7 Manufactured No 260 Each 3.0000 1 1

 Gasket  M 11/03/23

Location	Loc Qty	Loc Code
FP	3	
43245	1	
50927	2	

1367162

Wednesday, March 09, 2011 9:51:11 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:51:11 AM

Page 9

Work Order ID: 67131

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

440.0000

2

2



O-RING



Handwritten: 11/03/23

Location

Loc Qty

Loc Code

FP

440

103697

440

Handwritten: x2

NAS1611-010

Purchased

No

260

Each

309.0000

4

4



O-RING



Handwritten: 11/03/23

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

Handwritten: x4

NAS1611-013

Purchased

No

260

Each

243.0000

4

4



O-RING



Handwritten: 11/03/23

Location

Loc Qty

Loc Code

FP

243

115460

100

115589

28

115812

20

116582

95

Handwritten: x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:51:11 AM

Work Order ID: 67131

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/9/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

2,161.000

8

8



BOLT



117094 *CE*

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

AN960C10L

NAS1149C0332
R

Purchased

No

280

Each

61.0000

8

8



washer



1115832 *CE*

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

D3512-1

Manufactured

No

280

Each

1.0000

2

2



Wearplate



67104 *CE*

Location

Loc Qty

Loc Code

ST500

1

63954

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

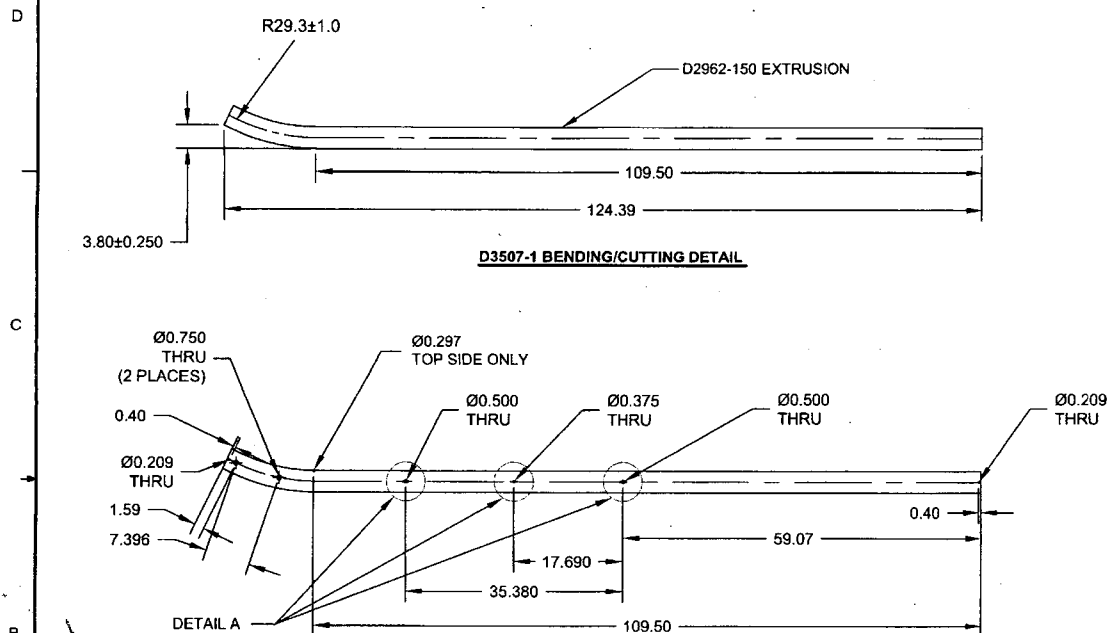
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

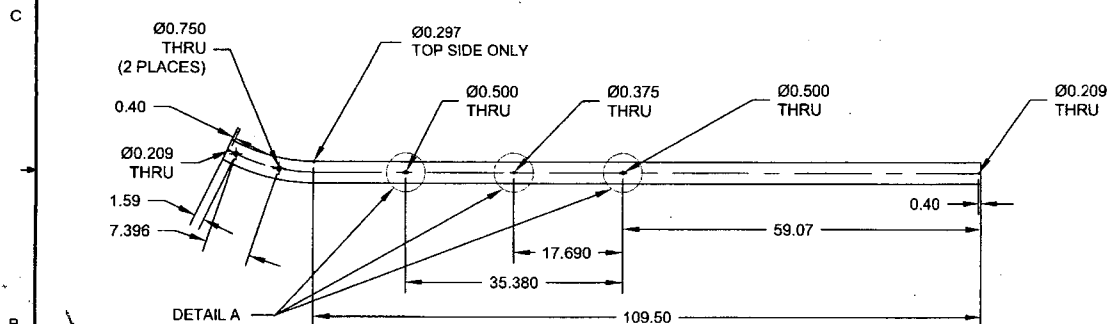
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

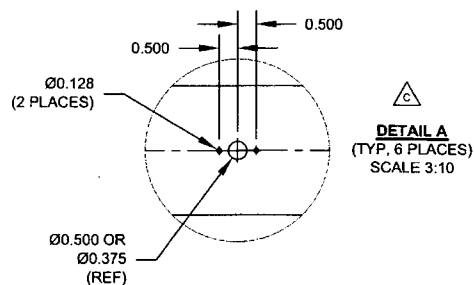
8 7 6 5 4 3 2 1



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

CL 11/03/09
W10:67131

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BA	D3507	SHEET 1 OF 2
APPROVED	BA	TITLE	SCALE
DE APPR.	BA	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
07.11.16

NO. 247

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 66661
Part number: D135-751-011
Description: 135 skid truck
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[] fail[]

Qualifier: Pat Jones Date of Test Coupon 11/03/17
Welder: Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld